

Work Order ID 96545

96545

Page 1

January-30-13 12:48:20 PM

Item ID: D2235-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Basket Rib

Stop

NS2

Start Date: 2/05/13 Start Qty: 2.00

2 C1

Cust Item ID:

Required Date: 2/15/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MUS

Date: 13-01-31 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2235	Rev B1
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100	0.00
-----	------

100 Large Fab

Large Fab	Memo	0.00
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Large Fab
1- Pick D3166-1 and cut as per dwg D2235 using DT83022- remove
identification markings on tube 3- deburr

(5) 13-4-22 10

110	0.00
-----	------

110 QC6- Inspect dimensions to drawing

Memo	0.00
------	------

Quality Control

LPL 13-4-22 DAS 24 8:39

(4)

120	0.00
-----	------

120 Packaging Identify as per dwg & Stock Location: WA4

Memo	0.00
------	------

Packaging

LPL 13-4-22 DAS 24 8:39

(4)

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____		NCR No. _____									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	Bending	Bend	Grain	Ovalized	Pressure/Forced						
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure						
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld						
	Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled						
	Cuffs	Contamination	Maintenance	Part Moved							
	Heat Treat	Countersink	Mislabeled	Positioned Wrong							
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other						
	Ripples in Bend	Drill Holes	Offset								
	Torque Waves in Extrusion	Drawing	Out of Calibration								
	Turning Sequence	Finish	Out of Sequence								
	Wave/Twist in Tube	Folio	Outside Dimensions								

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96545

Page 2

Item ID: D2235-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Basket Rib

Stop

NS2

Start Date: 2/05/13 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 2/15/13 **Req'd Qty:** 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

130

130

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

13/5/13
MF

13-4-25

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____ NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	Centre Not Concentric to O/S			General							
	Bending	Bend	Grain	Ovalized	Pressure/Forced						
	Cracks	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure						
	Crushed/Crimped.	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld						
	Cuffs	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled						
	Heat Treat	Contamination	Maintenance	Part Moved							
	Inspection Strip in Tube	Countersink	Mislabeled	Positioned Wrong							
	Ripples in Bend	Cut Too Short	Misread	Power Loss/Surge	Other						
	Torque Waves in Extrusion	Drill Holes	Offset								
	Turning Sequence	Drawing	Out of Calibration								
	Wave/Twist in Tube	Finish	Out of Sequence								
		Folio	Outside Dimensions								

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

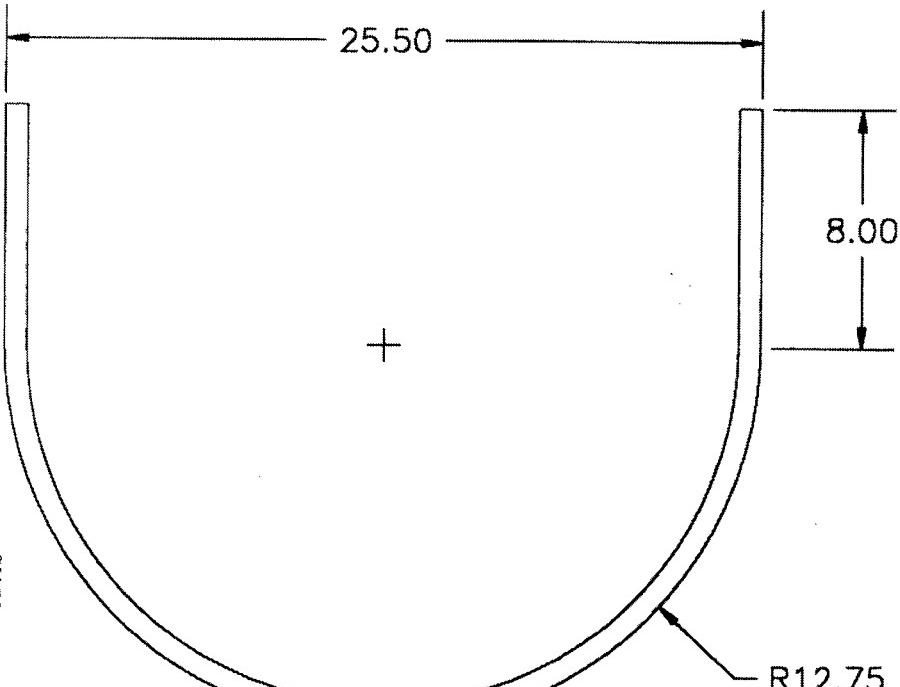
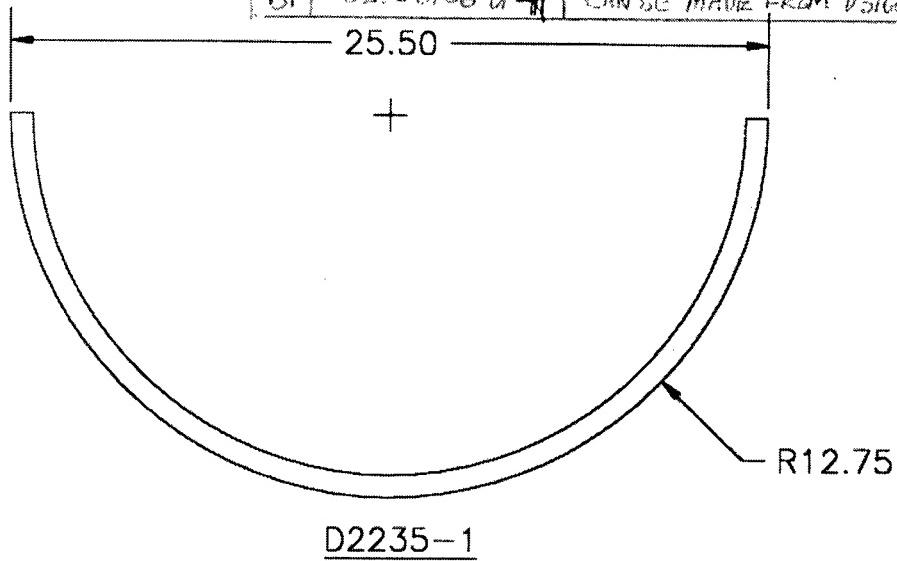
QA Closed: _____ Date: _____

Work Order:			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework	<input type="checkbox"/>	Skid-tube	<input type="checkbox"/>	Crosstube	<input type="checkbox"/>	Water Jet	<input type="checkbox"/>	Engineering
			Scrap	<input type="checkbox"/>	Machining	<input type="checkbox"/>	Small Fab	<input type="checkbox"/>	Prod. Eng. Coor.	<input type="checkbox"/>	Quality
			Use-as-is	<input type="checkbox"/>	Thermoforming	<input type="checkbox"/>	Finishing	<input type="checkbox"/>	Rec/Store/Packaging	<input type="checkbox"/>	Other
			Work Order Update	<input type="checkbox"/>	Large Fab	<input type="checkbox"/>	Composite	<input type="checkbox"/>	Supplier	<input type="checkbox"/>	
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear	General										
	Bending	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Ovalized	<input type="checkbox"/>	Pressure/Forced				
	Centre Not Concentric to O/S	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Temperature/Cure				
	Cracks	<input type="checkbox"/>	Broken/Damaged	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Weld				
	Crushed/Crimped	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Wrong Stock Pulled				
	Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>					
	Heat Treat	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>					
	Inspection Strip in Tube	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other				
	Ripples in Bend	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>		<input type="checkbox"/>					
	Torque Waves in Extrusion	<input type="checkbox"/>	Drawing	<input type="checkbox"/>		<input type="checkbox"/>					
	Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>		<input type="checkbox"/>					
	Wave/Twist in Tube	<input type="checkbox"/>	Folio	<input type="checkbox"/>		<input type="checkbox"/>					

DART

DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	SCALE

B1 02.08.06 (P) CAN BE MADE FROM D3166-1

CAN BE MADE FROM D3166-1 (B1)
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 96545 MCS
13-01-31